

Work Order ID 109899

\*109899\*

Page 1

December-05-13 10:59:43 AM

Item ID: D4909-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Support

Start Date: 12/05/13 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 12/13/13 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4909	A

100	HAAS CNC VERTICAL MACHINING #1	0.00				4	Ø		DAS 08 2-89
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\*100\*

HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FB209

Folio Rev: AA

Dwg Rev: A

Deburr

\*\*\*\*Program Batch #\*\*\*\*\*

110	QC2- Inspect parts off machine FAI/FAIB	0.00				4	Ø		DAS 08 2-89
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\*110\*

QC

Quality Control

Memo

0.00

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Page 2

### Quality Control

88-13-12-16

2

④

13-12-16

13/12/18

८५१३११२१४

# Picklist Print

December-05-13 10:59:42 AM

Page 1

Work Order ID: 109899

Parent Item: D4909-1

Parent Item Name: Support

Start Date: 12/05/13

Required Date: 12/13/13

Start Qty: 2.00

Required Qty: 2.00

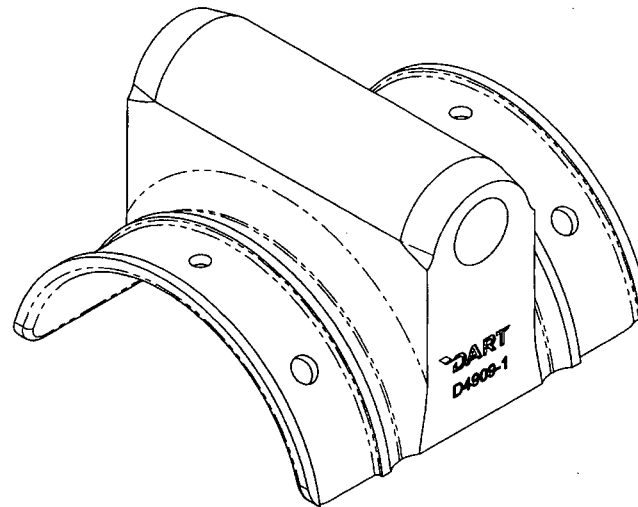
Comments: IPP REV:A NEW ISSUE 13-04-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4909-1TRN Support		Manufactured	No			100	Each	0.0000	1	2			

D4909-1TRN

B109901 x2

Jan 13.12.11



**D4909-1 SUPPORT**

**RELEASED**  
2013-08-06  
WJ

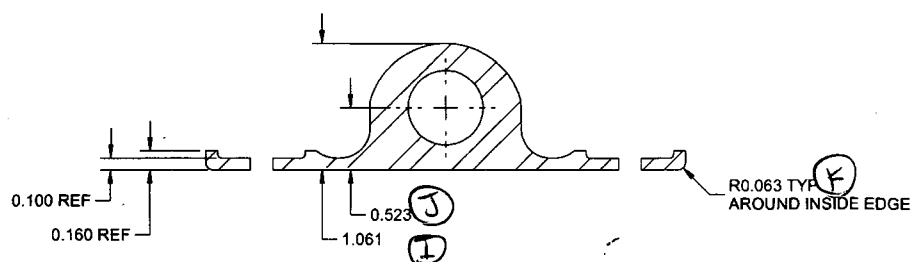
*w/o 109899*

**NOTES:**

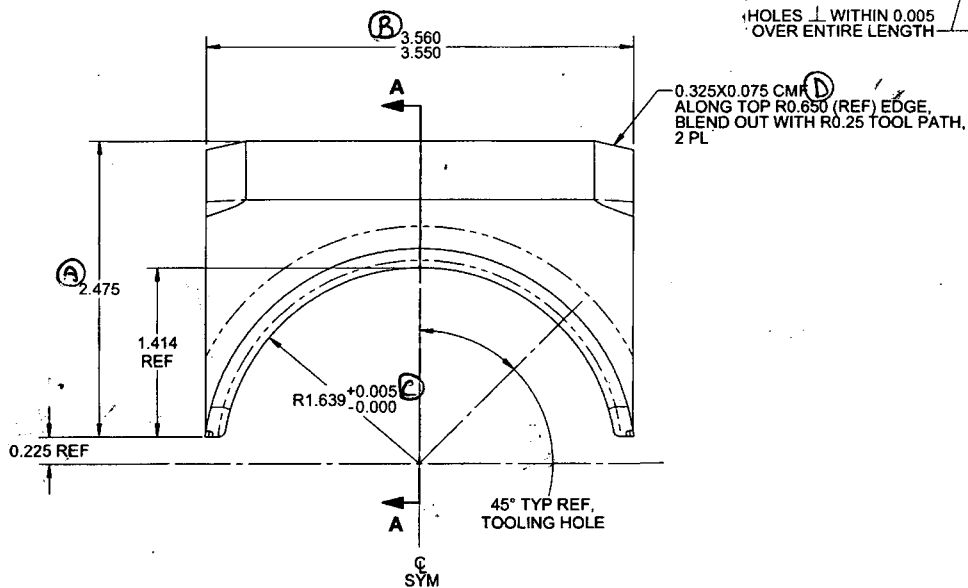
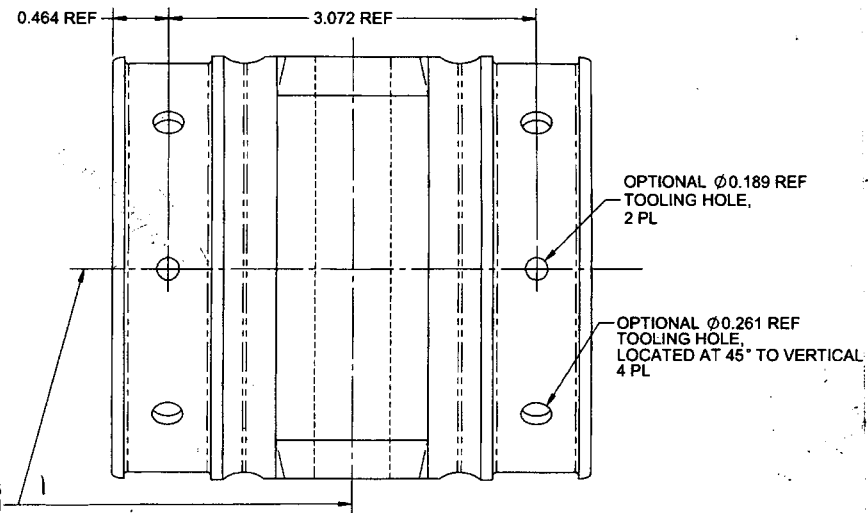
- 1) MATERIAL: MAKE FROM D4909-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D4909-1" IN INDICATED AREA  
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,  
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.90 lbs

A	NEW ISSUE	CP	13.04.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.04.08		

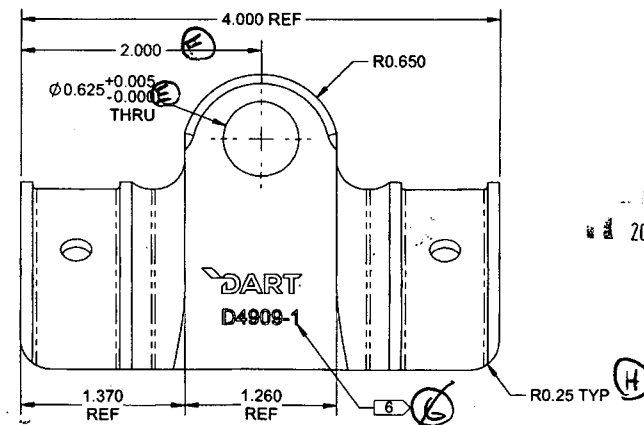
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4909</b>	REV. A
TITLE <b>SUPPORT</b>	SHEET 1 OF 3
SCALE NTS	
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**SECTION A-A**  
SCALE 1X

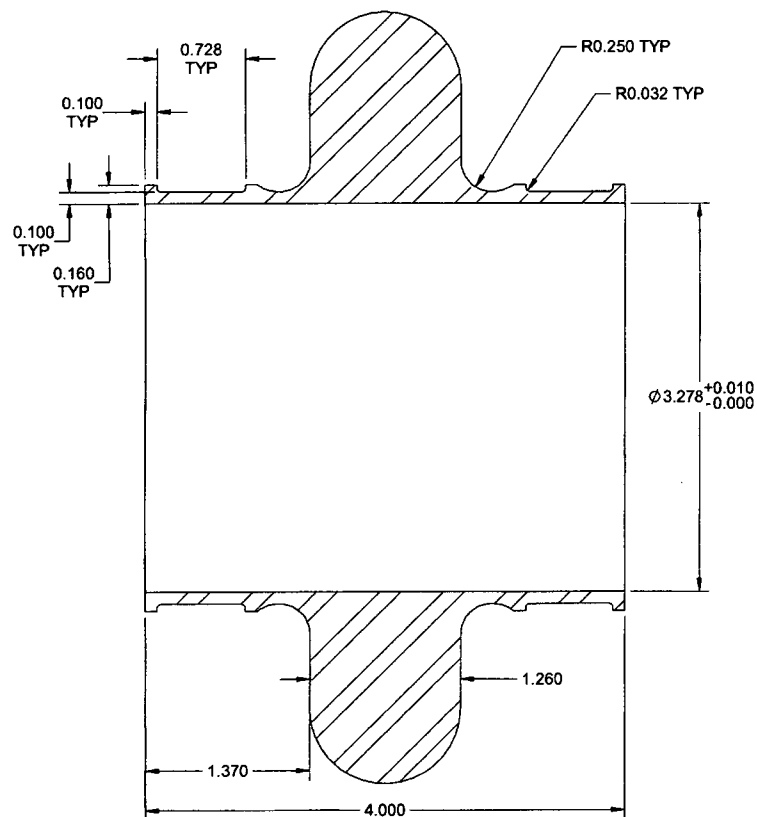


**D4909-1 SUPPORT**

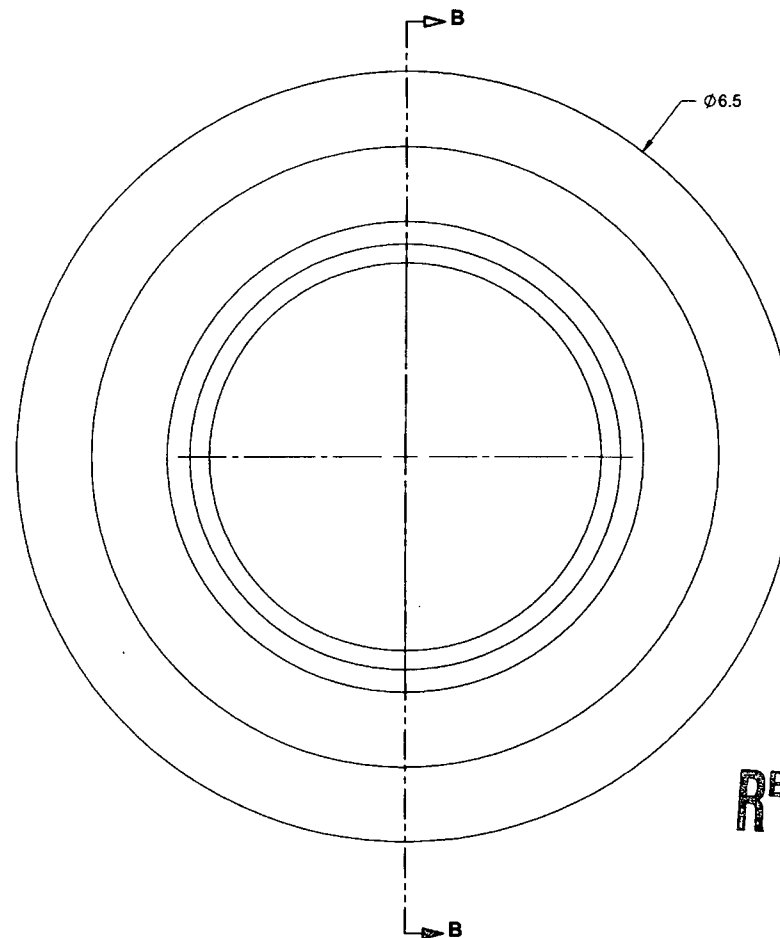


RELEASED  
2013-08-06

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4909</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SUPPORT</b>	NTS
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**SECTION B-B**



**D4909-1TRN TURNING DETAIL**

**NOTES:**

- 1) MATERIAL: 17-4PH / S17400 / TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R  
HEAT TREAT TO H900 CONDITION (900 °F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRc)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9.1 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO. <b>D4909</b>	REV. A
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		<b>SUPPORT</b>	SCALE
DE APPR.			NTS
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**RELEASED**  
2013-08-06

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	109899
<b>Description:</b> SUPPORT		<b>Part Number:</b>	D4909-1
<b>Inspection Dwg:</b> D4909 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual <sup>①</sup> Dimension	Accept <sup>②</sup>	Reject <sup>③</sup>	Method of Inspection <sup>④</sup>	Comments
2.475	+/- .010	2.477	2.476	2.475	2.473	
3.555	+/- .005	3.558	3.557	3.555	3.554	
R1.639	+0.005/-0.000	R1.640	R1.640	R1.640	R1.640	
0.325 x 0.075	+/- .010 / +/- .010	0.325 x 0.075	0.325 x 0.075	0.325 x 0.075	0.325 x 0.075	
φ 0.625	+0.005/-0.000	φ 0.626	φ 0.625	φ 0.626	φ 0.630	
2.000	+/- .010	2.000	2.001	1.998	1.996	
0.015	+/- .005	0.012	0.012	0.010	0.010	
R0.25	+/- .030	R0.250	R0.250	R0.250	R0.250	
1.061	+/- .010	1.065	1.061	1.063	1.062	
0.523	+/- .010	0.527	0.522	0.525	0.528	
R0.063	+/- .010	R0.063	R0.063	R0.063	R0.063	
.625 hole ⊥	.005 over entire length	0.002	0.0035	0.004	0.004	

<b>Measured by:</b> M.A. DAS	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 13/12/14	<b>Date:</b> 13-12-14	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15